

Work Order ID 65448

Monday, January 17, 2011 4:09:04 PM



Page 1

Item ID: D4055-3

Accept



Setup Start



Revision ID:

Item Name: Tank Aft End

Stop



Start Date: 1/18/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 2/1/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: UMF

Date: 11-9-18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D4055	A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4055

6061 . 063

Prog rev: 5

Dwg rev: A

Bill-2-7

(3)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Bill-2-7

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sulelos

(+3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

SB 11/02/03

(3)

Brake NC

140

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Sulozlos

(3)

Quality Control

150

Identify as per dwg & Stock Location: 141A

0.00



Packaging

Memo

0.00

11/12/03 (3) J

Packaging

W/O:		WORK ORDER CHANGES					
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Page 3

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Stop



Item Name: Tank Aft End

Start Date: 1/18/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 2/1/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/08
mf

11-02-08

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Monday, January 17, 2011 4:09:00 PM

Page 1

Work Order ID: 65448



Parent Item: D4055-3



Parent Item Name: Tank Aft End

Start Date: 1/18/2011

Required Date: 2/1/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM
10.11.23 now made in house DD verf:EC

IPP rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 		Purchased	No			100	sf	71.6000	1.5143	4.782			
6061-T6 .063 Sheet													

B11-2-7

Location

Loc Qty

Loc Code

MAT 35.6
116308 35.6
MAT21 36
113608 36

116623

116623

③

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 65448
Description: TANK AFT END		Part Number: D4055-3
Inspection Dwg: D4055-3, Rev: A		Page 1 of 1

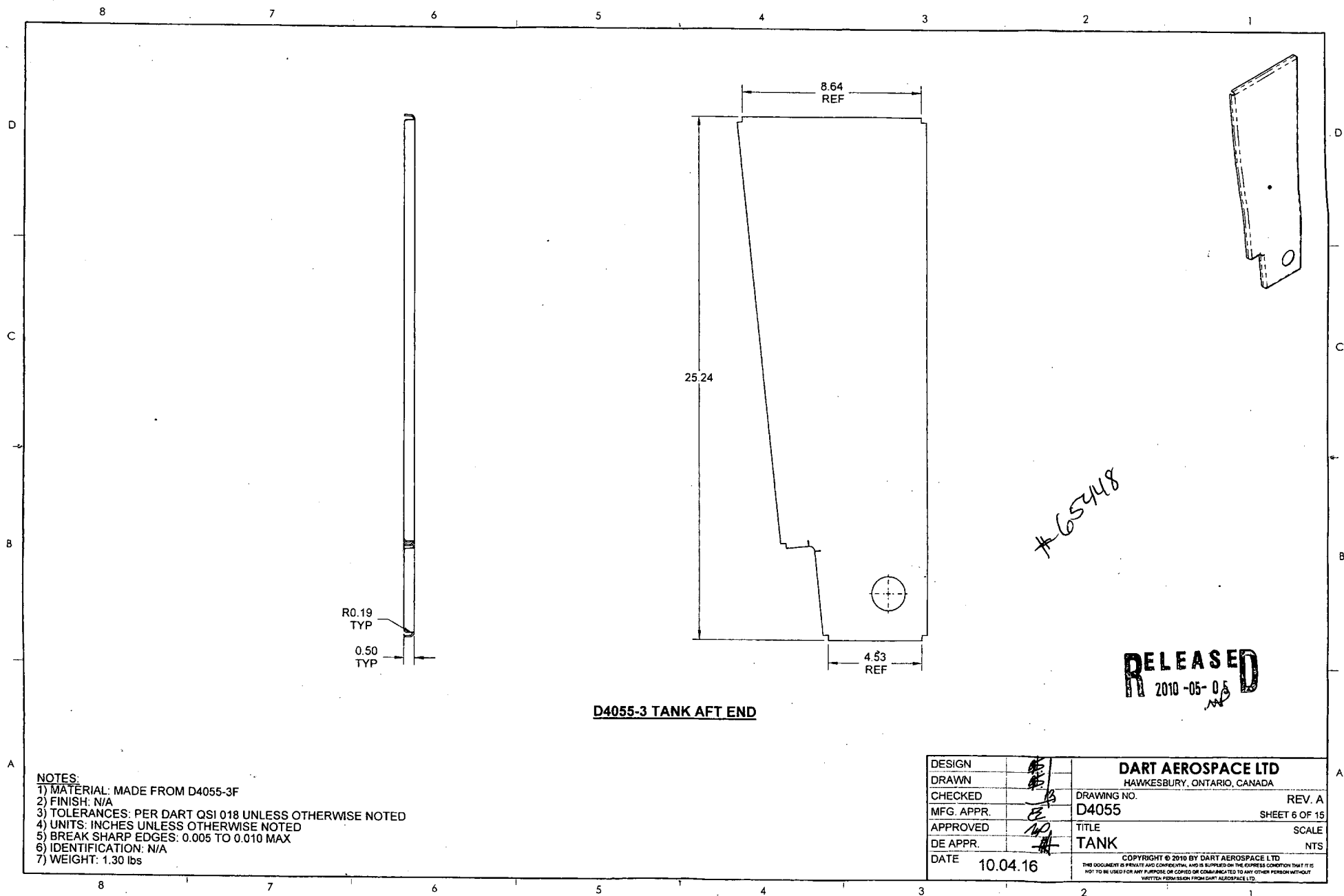
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.59	± .030	.594	X		V 1802	
.59	± .030	.594	Y		V	
23.34	± .030	23.34	b		T 1801	
25.34	± .030	25.34	2		T	
25.93	± .030	25.93	2		T	
21.62	± .030	21.620	1		T	
21.55	± .030	21.55	2		T	
25.40	± .030	25.40	2		T	
2.22	± .030	2.224	X		V	
5.13	± .030	5.126	X		V	
5.72	± .030	5.728	Y		V	
7.11	± .030	7.120	2		V	
7.76	± .030	7.770	2		V	
9.23	± .030	9.23	2		T	
9.82	± .030	9.82	Y		T	
.59	± .030	.594	X		V	
.63	± .010	.633	Y		V	

Measured by: RB	Audited by: S	Prototype Approval:
Date: 11-2-7	Date: 11/02/08	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



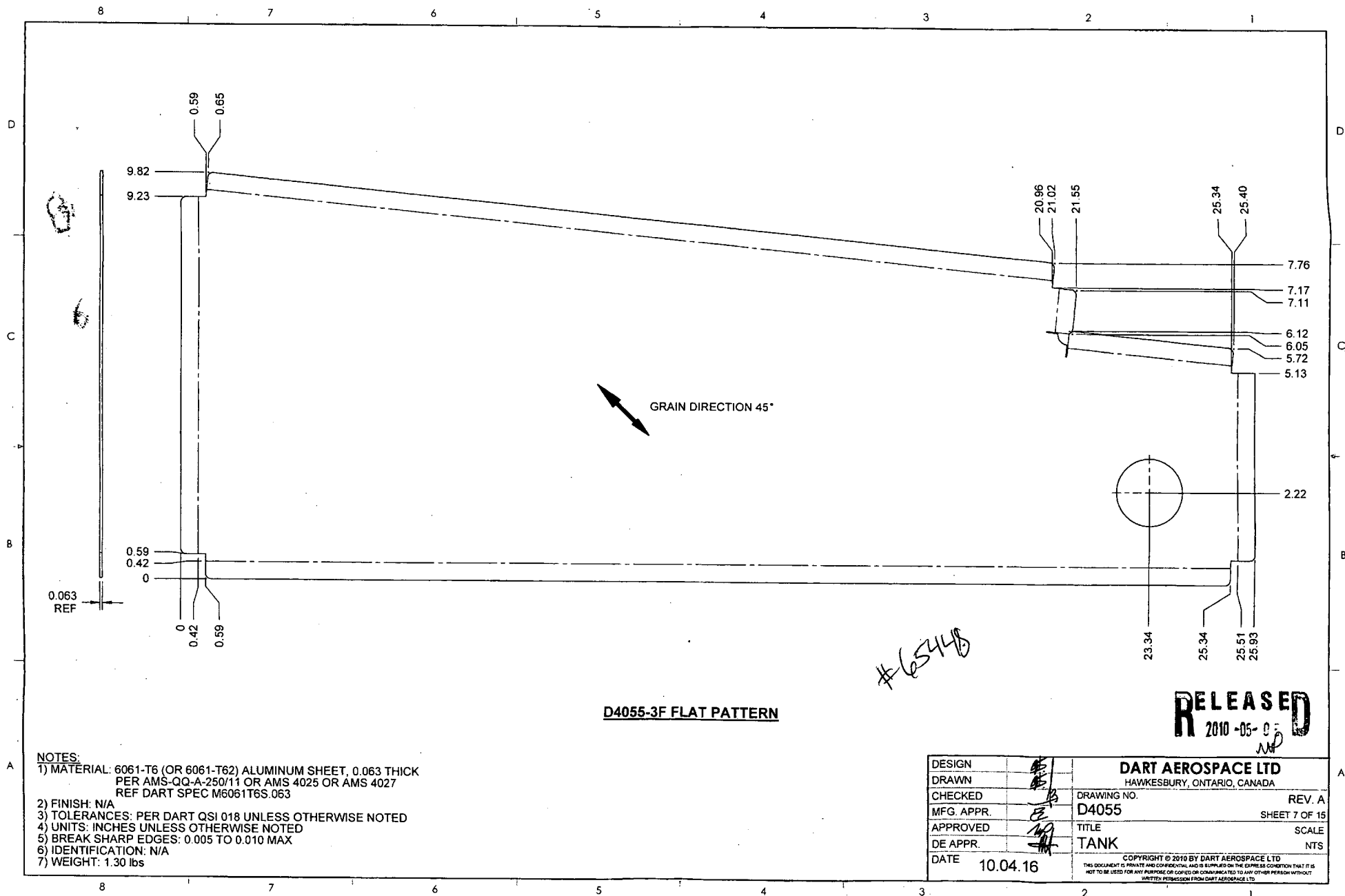
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NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.30 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4055	SHEET 7 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	10.04.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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